

Work Order ID 85706

June-13-12 4:06:31 PM

Item ID: D412-705-017

Revision ID:

Item Name: NI Gearbox Access Panel

Start Date: 13/06/2012 Start Qty: 4.00

Accept

N900040100

Setup Start

NS1

Required Date: 27/06/2012 Req'd Qty: 4.00

4
4

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

NR1

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

100

DC

DOCUMENT CONTROL

0.00

DAS
15
12/08/14

Document Control

0.00

Memo

Photocopy bluefile & type labels per PPPD412-705-017

CHG001

JB

110

Pick Kit

0.00

4

12/08/14 JB

110

Packaging

Memo

0.00

SP

120

QC4- 100% Inspect kits for completeness

0.00

DAS
15
12/08/14

12/08/14

120

QC

Memo

0.00

74

Quality Control

Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-13-12 4:06:34 PM

Page 1

Work Order ID: 85706

Parent Item: D412-705-017

Parent Item Name: NI Gearbox Access Panel

85706
D412-705-017

Start Date: 13/06/2012

Start Qty: 4.00

Required Date: 27/06/2012

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased	No			120	Each	117.0000	30	120			**

AN3C3A
Bolt

Location Loc Qty Loc Code

GA	70	
118352	70	
ST350	47	
120187	1	
121723	46	

D3255-041

D3255-041

Access Panel Assembly

D3255-042

D3255-042

Access Panel Assembly

Manufactured

No

120 Each 0.0000

** 0 4

3 x 85333
+ 86108

JB

MS20427M3-3

Rivet

MS20427M3-3

Manufactured

No

120 Each 1.0000

** 1 4

3 x 86102
+ 77821

JB

Purchased

No

120 Each 1,425.000

** 36 144

JB 12/08/29

Location Loc Qty Loc Code

GA	1363	
121114	1363	
ST318	62	
120930	3	
121350	59	

121114

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-13-12 4:06:35 PM

Page 2

Work Order ID: 85706**Parent Item:** D412-705-017**Parent Item Name:** N1 Gearbox Access Panel***85706***
D412-705-017**Start Date:** 13/06/2012**Required Date:** 27/06/2012**Start Qty:** 4.00**Required Qty:** 4.00

MS21060-L3K

Purchased

No

120

Each

121.0000

18

72

122141

JB

MS21060-L3K

Nut Plate

MS9321-09

Purchased

No

120

Each

292.0000

30

120

18 X 122141

JB

12/08/29

MS9321-09

Washer

Location Loc Qty Loc Code

302 26 _____

121652 26 _____

ST303 95 _____

120142 95 _____

Location Loc Qty Loc Code

ST296 292 _____

119546 50 _____

120142 2 _____

120867 40 _____

121524 200 _____

102 X 121524

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

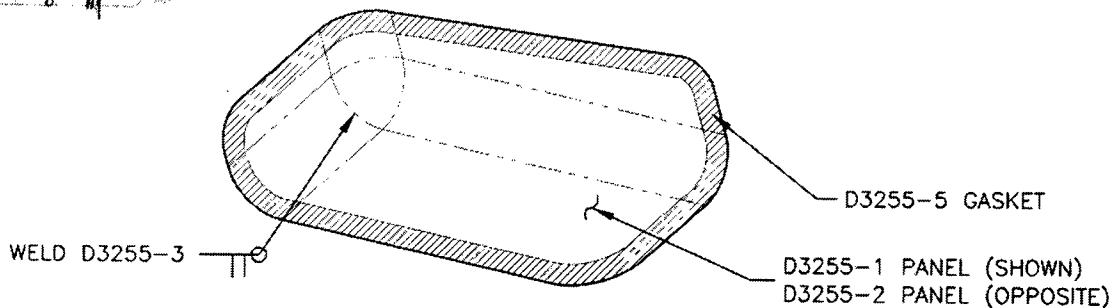
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

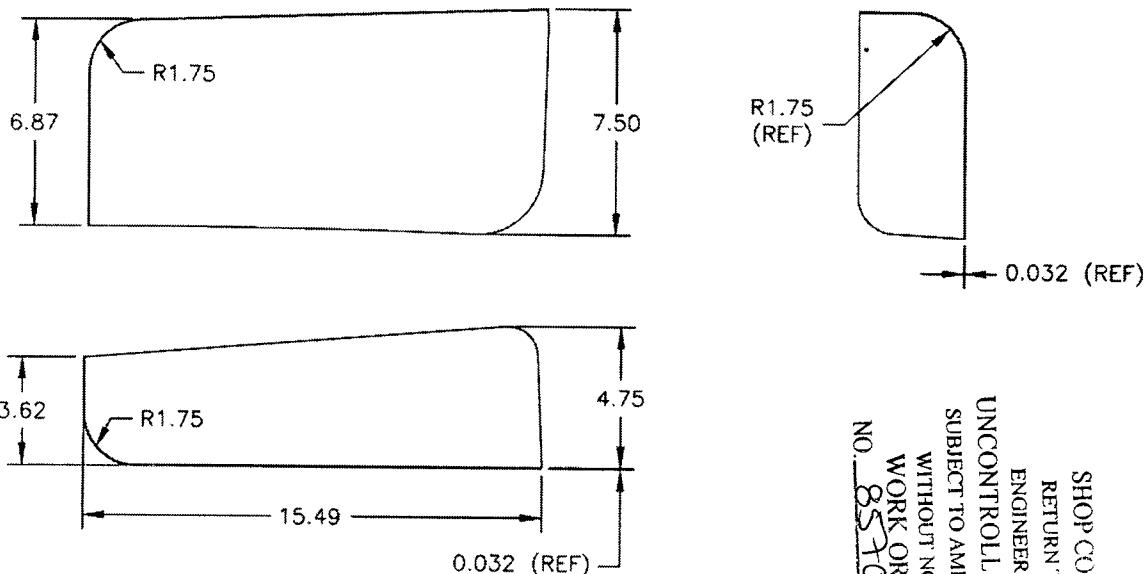
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3255		SHEET 1 OF 4
DATE		TITLE	SCALE	
04.12.06		ACCESS PANEL ASSEMBLY	1:6	
A	04.01.27	NEW ISSUE		
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098		

RELEASED
05.01.18 *ff*



**D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL
D3255-2 OPPOSITE**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85766 *HLJ*
12/06/14

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

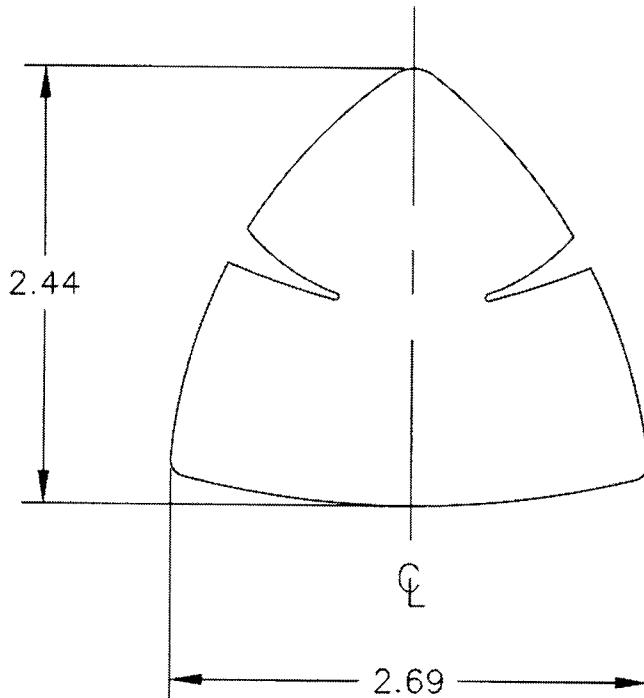
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN T.F	DRAWN BY T.F	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 49	APPROVED H	DRAWING NO. D3255	REV. B	SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1	

RELEASED
05.01.18 ~~H~~



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

2008
01/08

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

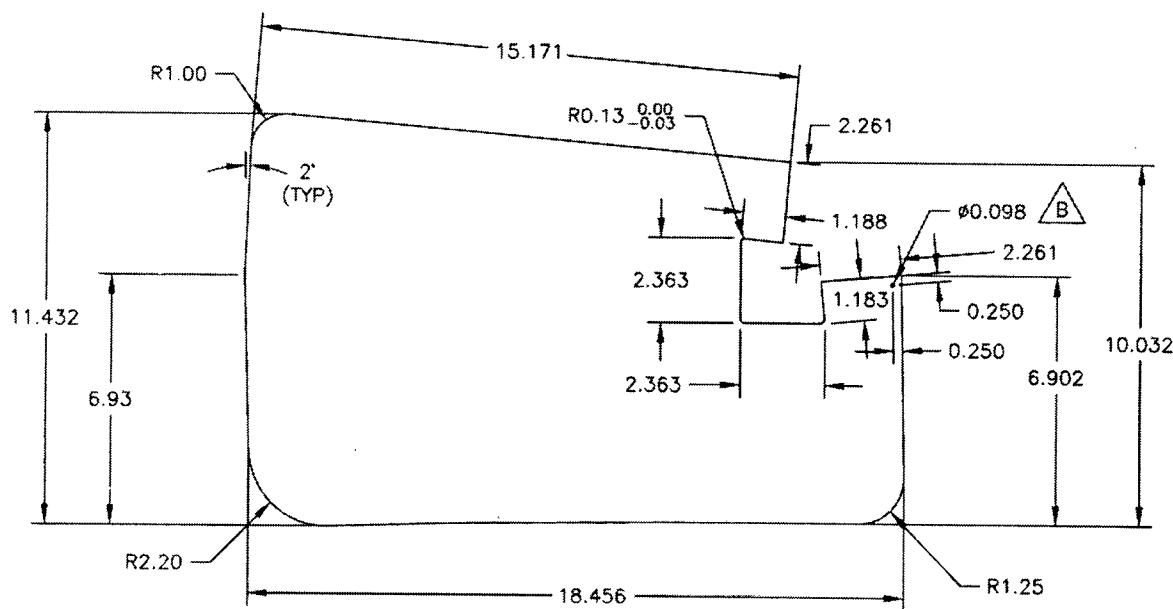
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KT	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED IP	APPROVED H	DRAWING NO. D3255	REV. B	SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE	1:5

RELEASED
05-01-18

D3255-1/-2 FLAT PATTERND3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 05/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

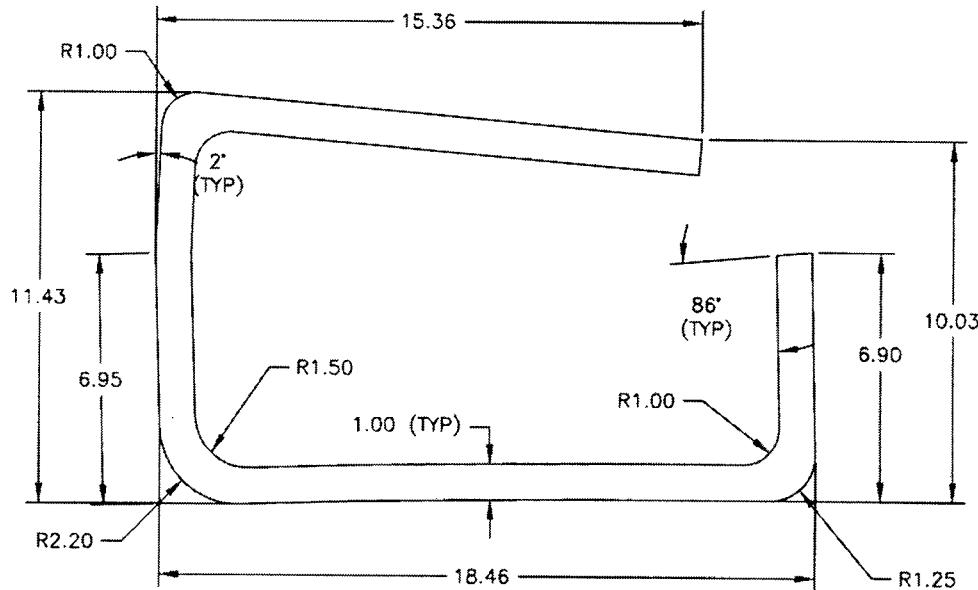
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>IP</i>	APPROVED <i>PF</i>	DRAWING NO. D3255	REV. B	SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

RELEASED
05.01.18 *PF*



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

gasket

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
1							D3245-041	ACCESS PANEL ASSEMBLY, LH
1							D3245-042	ACCESS PANEL ASSEMBLY, RH
2							D3245-043	DOOR ASSEMBLY
2							D3245-9	GASKET
2							D3245-11	GASKET
2							D3245-13	GASKET
	1						D3255-041	ACCESS PANEL ASSEMBLY, LH
	1						D3255-042	ACCESS PANEL ASSEMBLY, RH
	1						D3256-1	ACCESS PANEL
	1						D3256-3	GASKET
		1					D3259-041	ACCESS PANEL ASSEMBLY, LH
		1					D3259-042	ACCESS PANEL ASSEMBLY, RH
			1				D3307-041	ACCESS PANEL ASSEMBLY
					30		AN3-3A	BOLT
	22	30		6			AN3C-3A	BOLT
	3						AN3C-4A	BOLT
				30			AN960JD10	WASHER
16	44	36		12			MS20427M3-3	RIVET
					2		MS21051-L3K	NUT PLATE
8	22	18		6			MS21060-L3K	NUT PLATE
				18			MS21069-L3K	NUT PLATE
	25	30		6			MS9321-09	WASHER

